

Work Order ID 83337-1

April-17-12 2:15:37 PM

ASAP Split

83337

Item ID: D3295-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Floor Window

Stop *NS2*

Start Date: 17/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/17

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3295

Rev D

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3295 Dwg Rev: D Prog Rev: D 2-
Remove plastic and wrap in saran wrap. 2-Deburr if necessary

1/8" 9034 Lexan sheet

10

0

Jm/R
12-4-19

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10

0

Jm/R
12-4-19

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

507/4/20

40

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

10

Cust Item ID:

10

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stamp

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

Assemble as per Dwg D3295. Put window in plastic wrap.

QC5- Inspect part completeness to step on W/O

0.00

140

Memo

0.00

QC

Quality Control

Identify as per dwg & Stock Location: _____

0.00

150

Memo

0.00

Packaging

Packaging

W/O: 83337-1

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3295-041 PAR #: _____ Fault Category: Small Fab/waste NCR: Yes No DQA: hbk Date: 12/05/14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 12/5/14

NCR: 12-1403

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/5/12	#130	Scratches found in windows Dumi assembly. R.C. Pass / new operator on waste 34	S 12/5/12 asizayz	Scrap + Destroy 24x5 unable to remove	12-05-02 FF	S 12/05/12	S 12/05/12 252042	S 12/5/12

NOTE: Date & initial all entries

Work Order ID 83337

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83337

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Item ID:	D3295-041	Accept	*N9000040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Floor Window				Stop	*NS2*
Start Date:	17/04/2012	Start Qty: 10.00	*10*	Cust Item ID:		
Required Date:	01/05/2012	Req'd Qty: 10.00	*10*	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

P12-05-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-17-12 2:15:41 PM

Page 1

Work Order ID: 83337

83337

Parent Item: D3295-041

D3295-041

Parent Item Name: Floor Window

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP C05.06.20D3295-1 no longer made in-houseKJ/JLM
IPP Rev:D Added DT8822 07-03-20 JLM
IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1		Manufactured	No			100	Each	0.0000	0	0			
D2728-1									**				
Dart Logo label													
MLEXS.125-9034-01		Purchased	No			140	sf	217.4000	1.24	13.05263			
MI FXS 125-9034-01									**				
1/8" 9034 Lexan Sheet													

Location

Loc Qty

Loc Code

MAT019

217.4

117273

122.4

119591

95

117273

Jm/IP
12-11-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	83337
Description: Window		Part Number:	D3295
Inspection Dwg: D3295	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	0.157	✓		vern	HB-02
17.13	+/-0.030	17.13	✓		MT	HB-01
10.43	+/-0.030	10.436	✓		vern	Prod-W-J-02
14.35	+/-0.030	14.35	✓		MT	HB-01
8.98	+/-0.030	8.999	✓		vern	Prod-W-J-02
0.625	+/-0.010	0.622	✓		vern	HB-02
7.109	+/-0.010	7.119	✓		vern	HB-02
15.845	+/-0.010	15.845	✓		MT	HB-01
2.308	+/-0.010	2.314	✓		vern	HB-02
5.420	+/-0.010	5.414	✓		vern	HB-02
9.402	+/-0.010	9.404	✓		vern	HB-02 Prod-W-J-02
1.312	+/-0.010	1.310	✓		vern	HB-02
6.260	+/-0.010	6.254	✓		vern	HB-02
12.520	+/-0.010	12.520	✓		MT	HB-01
0.313	+/-0.010	0.319	✓		vern	HB-02
3.750	+/-0.010	3.748	✓		vern	HB-02
8.150	+/-0.010	8.149	✓		vern	HB-02 Prod-W-J-02
9.006	+/-0.010	9.001	✓		vern	Prod-W-J-02
0.125	+/-0.010	0.122	✓		vern	HB-02

Measured by: JM/IB	Audited by: J	Prototype Approval:	N/A
Date: 12-4-19.	Date: 7/4/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3295-041	KJ/EC/DD	

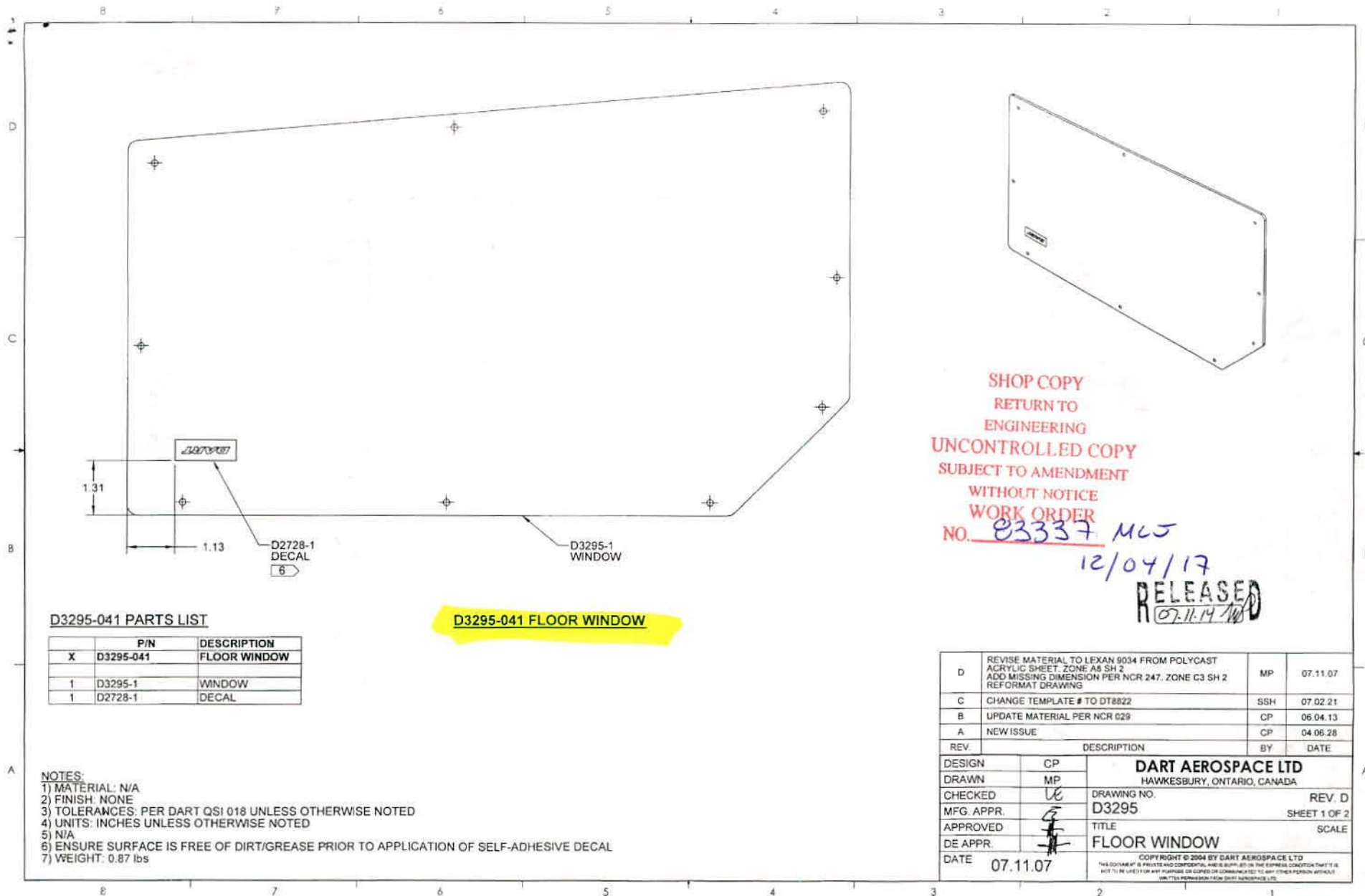
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

*NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 03337 MLJ

12/04/17

RELEASED
07.11.14

D3295-041 PARTS LIST

	P/N	DESCRIPTION
X	D3295-041	FLOOR WINDOW
1	D3295-1	WINDOW
1	D2728-1	DECAL

D3295-041 FLOOR WINDOW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) N/A
- 6) ENSURE SURFACE IS FREE OF DIRT/GREASE PRIOR TO APPLICATION OF SELF-ADHESIVE DECAL
- 7) WEIGHT: 0.87 lbs

D	REVISE MATERIAL TO LEXAN 9034 FROM POLYCAST ACRYLIC SHEET, ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247, ZONE C3 SH 2 REFORMAT DRAWING	MP	07.11.07
C	CHANGE TEMPLATE # TO DT8822	SSH	07.02.21
B	UPDATE MATERIAL PER NCR 029	CP	06.04.13
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	UC	DRAWING NO.	REV. D
MFG. APPR.	E	D3295	SHEET 1 OF 2
APPROVED	J	TITLE	SCALE
DE APPR.	J	FLOOR WINDOW	
DATE	07.11.07	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

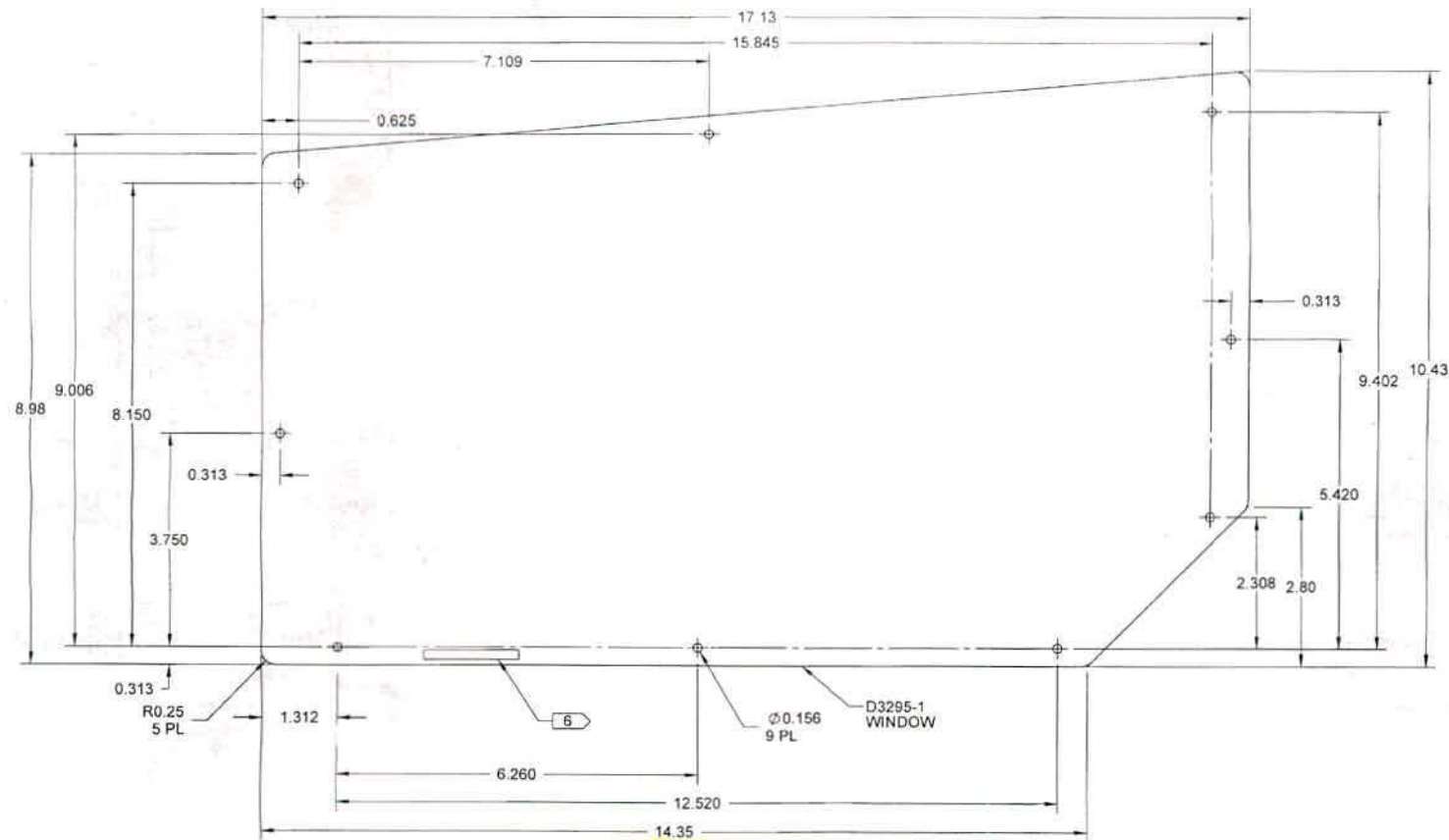
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83337



RELEASED
07-11-14

D3295-1 WINDOW

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK (REF DART SPEC. MLEXS.125-9034-01)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041", USE LETTERS 0.125 TO MAX DEPTH OF 0.005
LOCATE APPROXIMATELY AS SHOWN
- 7) WEIGHT: 0.87 lbs

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	LE	DRAWING NO.	REV. D
MFG. APPR.	IS	D3295	SHEET 2 OF 2
APPROVED	CH	TITLE	SCALE
DE APPR.		FLOOR WINDOW	
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